**₽**Date

Thursday, 24/07/2008 2:36:36 PM

User:

Julie Lecocq

### **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: HIGH AFT X-TUBE 412

**Estimate Number** 

: 40749 : 10559

P.O. Number

: 24/07/2008

Part Number

: D412664203

This Issue

S.O. No. :

**Drawing Number** 

: D412-664-243 REV D

Prsht Rev.

: NC

Project Number

: N/A

First Issue

: //

: CROSSTUBES

: D **Drawing Revision** 

: 12/08/2008

**Previous Run** 

: 40119

Material

Qty:

1 Um:

Each

Written By

Comment

Checked & Approved By

: Est Rev:E 04.02.16

Est Rev:F 06-03-29

Reformat; Added D3189-1 K/DS Remove Coments on Pick List JLM

Est Rev.G 06.12.08

per ECN 886

EC

**Due Date** 

Est Rev:H 07-04-30

As per Rev D

add comment in seq. 21 DD verified Est Rev:I 08-06-12

by:EC

#### **Additional Product**

Job Number:



Sea. #:

Description:

DOCUMENT CONTROL

1.0 DC



Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

2.0

Comment: DOCUMENT CONTROL

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D412664203TRN

Crosstube Turning Detail



Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch <u>8402/5</u>

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

FL 8-7-30

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES



W/O:		WORK ORDER O	HANGES	<del></del>	•		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	<b>\</b> :	Date:	

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, 24/07/2008 2:36:36 PM Date: User: Julie Lecoca **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Job Number: 40749 Part Number: D412664203 Job Number: Description: Seq. #: Machine Or Operation: **CROSSTUBES RESOURCE 1** CROSSTUBES 6.0 Comment: LANDING GEAR RESOURCE 1 98-7-31 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 2-Ream hole to finish size in tube as per Dwg D412-664-243using drill Jig DT8550 & DT8551.Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 HAND FINISHING RESOURCE #1 7.0 HAND FINISHING1 AWM 8-9-1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 10.0 OUTSIDE SERV.10 **OUTSIDE SERVICES -skids** Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 038Or C208/08/05 Issue P/O: 6264 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order PACKAGING RESOURCE #1 PACKAGING ' 11.0 Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order.

Dart Ae	rospace	Ltd						4.1
W/O:			WO	RK ORDER CHANGE	ES			
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Part No	· ·	PAR #:	Fault Categ	ory:	NCR: Yes N	o <b>DQA:</b>	Date:	
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D.4.T.F.	0	Description of NC		Corrective Action Section	n B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

NCR:		WORK ONDER HOR-COM ONMANCE (NCK)						
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Thursday, 24/07/2008 2:36:36 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Job Number: 40749 Part Number: D412664203 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 12.0 QC5 08 08 05 Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 SPRAY PAINTING 13.0 Comment: SPRAY P 1-Prime inside and outside crosstube as per QSI 005 4.2 \(^{\circ}\) 08 08 05 M 2-Paint outside crosstube with White Imron as per QSI 005 4.2 QC14 14.0 **Comment:** Inspect Spray Paint 08-08-06 Wrap in plastic bag to protect from scratches D3595063570 RUBBER CUSHION 15.0 4.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Total: **Rubber Cushion** 08 08 0 Batch: 35126 D2856600 Abrasion Strip 16.0 Comment: Qty.: Total: 1.7640 f(s) 1.7640 f(s)/Unit Pick: Description Batch Qty Part number 2 D2856-600(Cut to 10.090") Abrasion Strip 36398 D28961 17.0 Total: Comment: Qty.: 1.0000 Each(s)/Unit 1.0000 Each(s) Pick: Qty Part number **Description Batch** 08 Support\_3341 1 D2896-1 D31891 Chafing Shield 18.0 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: **Description Batch Qty Part number** 3788<sup>U</sup> 08 08 Chafing Sheild\_ 2 D3189-1 Form: rprocess

Page 3

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
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Thursday, 24/07/2008 2:36:36 PM Date: Julie Lecocq User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Job Number: 40749 Part Number: D412664203 Job Number: Description: Seq. #: **Machine Or Operation:** Clamp(per MIL-DTL-8783C) MS2192028 19.0 Comment: Qty.: 4.0000 Each(s) 4.0000 Each(s)/Unit Total: Pick: **Description Batch** Qty Part number Clamp 108120 4 MS21920-28 clamp(per MIL-DTL-8783C) MS2192030 20.0 Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) clamp(per MIL-DTL-8783C) batch: 106810 CROSSTUBES 21.0 Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-203 1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 08 08 07 (I) 2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs Batch: 107621 6398 Magnobond Expiry Date: 08 2000 Time: 1045AM 3-Install clamps as per Dwg D212-664-203 using installaition jig DT9024 with 0.010 thick brass shims on both chafing sheild (D3189-1). Torque clamps to 80-100 in lb. INSPECT WORK TO CURRENT STEP QC5 22.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 23.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit

Dart Ae	rospace	Ltd							
W/O:			WC	ORK ORDER CHANGES					································
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•	ursday, 24/07/2008 2:36:36 PM ie Lecocq	<b>D</b> 01 1		
		Process Sheet		
Customer	: CU-DAR001 Dart Helicopters Service	ces <b>Drawing Nam</b>	e: HIGH AFT X-TUBE 412	
Job Number	·: 40749	Part Numbe	r: D412664203	
Job Number:				
Seq. #:	Machine Or Operation:	De	escription :	
24.0	AN640A	Bolt	1188111188111881	
Comm	nent: Qty.: 4.0000 Each(s)/Unit	Total: 4.0000 Each(s)		₽·
U	Bolt Batch: <u>M1017</u> 11			SSI
25.0	AN641A	Bolt		/
Comm	nent: Qty.: 2.0000 Each(s)/Unit	Total: 2.0000 Each(s)	•	_
	Bolt Batch: <u>MIOFO13</u>			50
26.0	AN960JD616	Washer		
Comm	nent: Qty.: 18.0000 Each(s)/Unit	Total: 18.0000 Each(s)		
	Washer Batch: <u>M/01</u> 959			SO
27.0	MS21042L6	Nut		
		· ·		(x)
Z Comm	nent: Qty.: 6.0000 Each(s)/Unit	Total: 6.0000 Each(s)		•
	Nut Batch: <i>W_0</i> \$077	X/\$/8		SØ
28.0	QC4	INSPECT 100% KITS FOR C	OMPLETENESS	,
				-
Comm	ent: INSPECT 100% KITS FOR CO		) 8/8/8 (x	) /
29.0	PACKAGING 1	PACKAGING RESOURCE #1		(A)
Comm	IIIIIII IIIII IIIIIIIIIIIIIIIIIIIIIIII			(V)
. Comm	Identify and pack for shipping			
·		ged if curing time is less than 12 hrs, se	ee step 27 for application time & date	
	Time & date of packaging:	19. 8th, 2008 @ 10:15 An	^ 1 /	^
	Location:		4/8/9	s\$)
		1) .	PI VI V	<del>- /</del>
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Page 5				Form: rprocess

Page 5

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Date:

Thursday, 24/07/2008 2:36:36 PM

User:

Julie Lecocq

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 40749

Part Number: D412664203

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

30.0

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

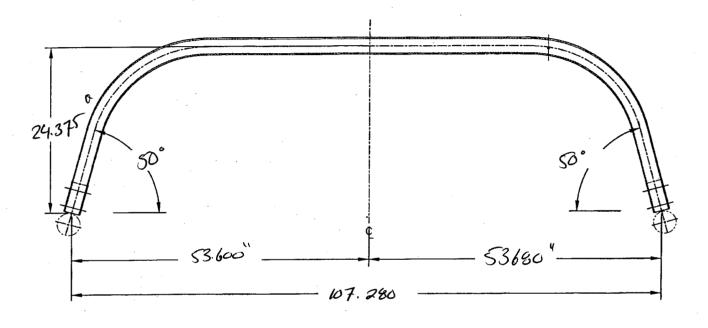


MF 08-08.08

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DART AEROSPACE LTD	Work Order:	4049
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



	. 0	comments	
•			
	QC15 Inspection	0,,	
	Date	08/02/20	

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	
В	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	fr
			- 7	

Dart Ae	rospace l	Ltd							
W/O:			WC	RK ORDER CHANGES	<b>3</b>			<del></del>	
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	y Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Categ	jory: l	NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date:	<del> </del>
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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DESIG	PH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	ŒD 🕜	APPROVED	DRAWING NO. REV. D
	9)	4	D412-664-243 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	3.09		CROSSTUBE ASSEMBLY (412 HI AFT) NTS
Α		01.10.17	NEW ISSUE
В		05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES
С		06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30
D		07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570

RELEASE	٠.
07.04.24	-

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### **GENERAL NOTES:**

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- MATERIAL: MANUFACTURED FROM D6009-129 FINISHED LENGTH = 124.09±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART 005 4.2
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE 5) SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE **UNACCEPTABLE**
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

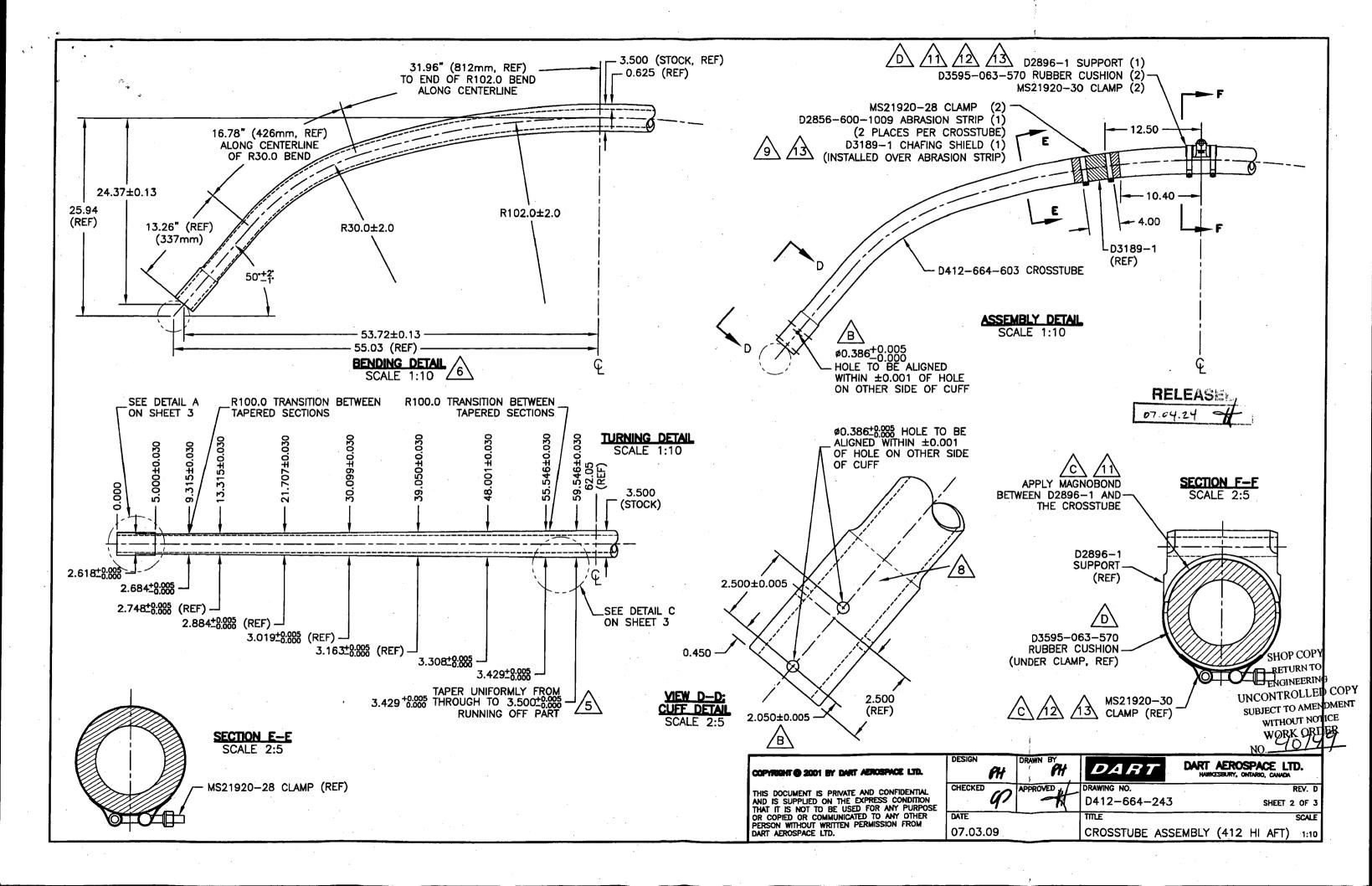
RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

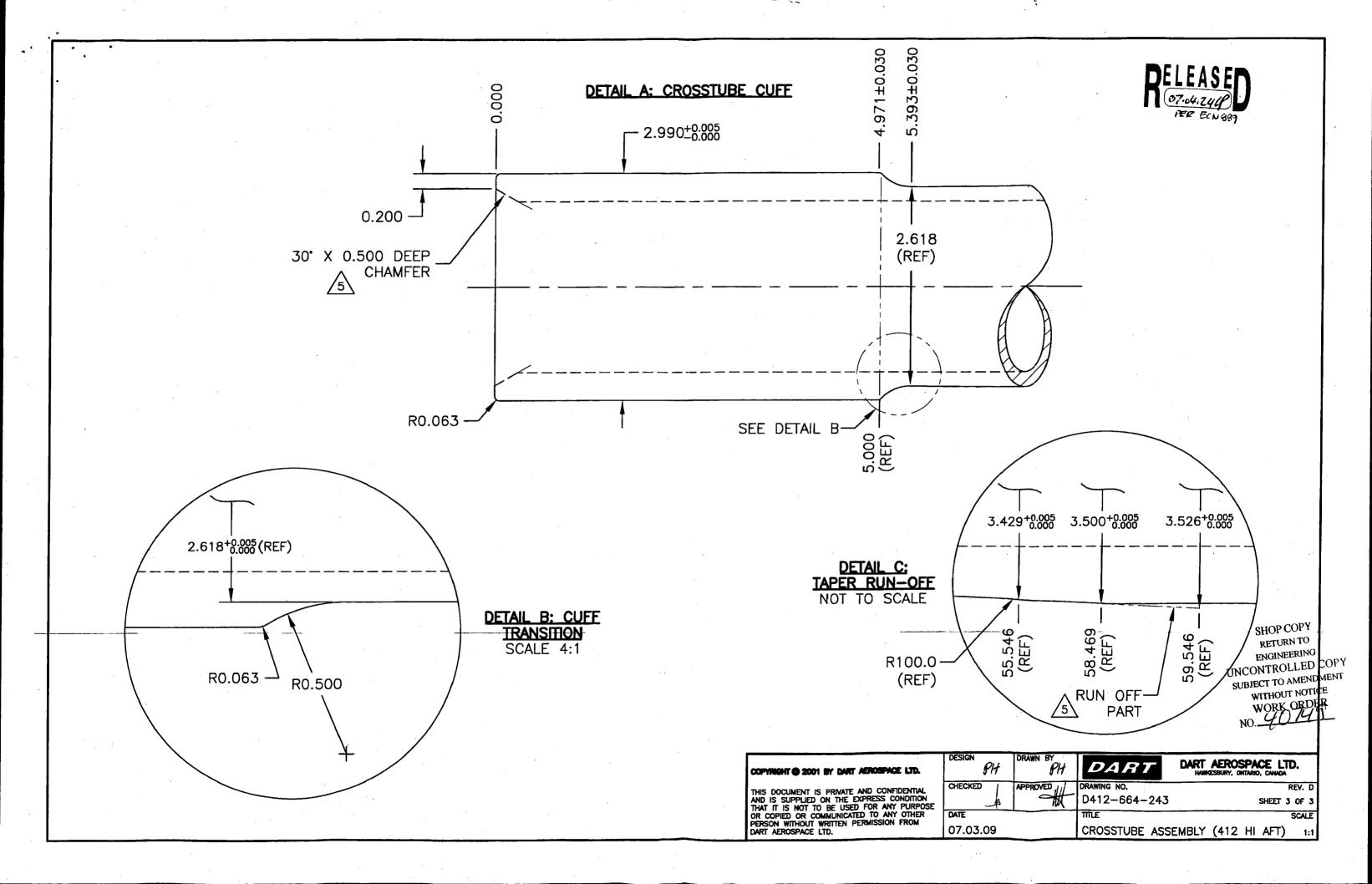
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W/O:		WORK ORDER CHANGES								
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QA: N/C Closed: \_\_\_\_ Date: \_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Varification						
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## LIQUID PENETRANT TEST REPORT

P- 08930

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ACONE!!					Page	OF 1
	S 1- A			n fatha		
CLIENT	Dart Aerospace Linda Lacelle 1270 Aberdeen st.		DATE	August 2+4 20. 188-08-14	TIME	AM 🗀 PM 🗀
ATTENTION	Linda Lacelle			188-08-16	126	
ADDRESS	1270 Aberdeen st.		PO/WO No.	6864		
	Hankesbury, Ontari	<u>o</u>	WORK LOCATION	Haw Kesbe	7.59	
	<b>J</b>		ACCEPTANCE STD	How Kes be ASTM 1417/ass	03 & REV./DA	TE 2005
PROJECT	High AFT X-TUBE(412)	), 212/205	High AF	TX-16BEAS	EMBIY, 2	663 AFT X-10B
ITEM(S) EXAMINED	Job#(40749),40750,40	507,405	100, 4054	<u> </u>		
JOB DESCRIPTION	PROCEDURE NO. LT-XX	XX REV./DATE		TECHNIQUE NO: LT-XXX	x-xxx Rev./Da	TE
PART NO. 1741260	64203, D212664201, D2066	67201	MATERIAL Allo	dune alymin	Z#HICKNESS _	
SCOPE WE	J. 1. 11	penet	rant insc	pection car	ried or	it on 100%
	external surface					
TEST DETAILS						
Mercion	☐ FLUORESCENT ☐ V	ISIBLE	WATER WASH		REMOVABLE	☐ POST EMULSIFIED
FAMILY BRAND	Magnaflix		BLACK LIGHT S/N	634955 ¥OUTPUT >	1000 μ W/cm²	AMBIENT < 2 fc
PENETRANT Z	L 64 MINIMUM DWELL TIME		LIGHTING EQUIP. 1 OTHER	¥FLASHLIGHT ☐ TROUBL	ELIGHT LE OUT	PUTS TOU IC WE SURFACE
PENETRANT REMOV	MINIMUM DRY TIME  MINIMUM DWELL TIME	>10 <b>M</b> in. 10 <b>M</b> in.	LIGHT METER S/N		CAL DU	E DATE Dec 16 /08
DEVELOPER TYPE	Non Aqueous 🔲 Aqueous	☐ DRY				
TEST SURFACE						CLEAN BARE METAL
SURFACE CONDITIO		DED 0°F TO 10°C/50°	☐ MACHINED	Shot Blasted  10°C/50°F to 52°C		> 52°C/125°F
RESULTS-	TURE   < - 4°C/ 20°F	0 F 10 10 C/30		10 0/00 1 10 02 0		
ITEM I	COMMENTS	ACCEPT REJECT				
	11: ACCEPTABLE					
405	7: ACCEPTABLE					
4050	B. ACCEPTA BLE	1				
14036	19) ACCEPTABLE			××××××××××××××××××××××××××××××××××××××	$\mathbb{Z}^{2n}\mathbb{Z}^{2n}$	
	50: ACCEPTABLE				b	
4043	o. ACCEPTIBLE	-				
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and the second s						
Scope of Services The agreement of Acuren G	roup Inc. to perform services extends only to those services provi ents and expressions of opinion reflect the opinions or observation	ded for in writing. Under	r no circumstances shall suc pased on information and a	ch services extend beyond the perfor ssumptions supplied by the owner/op	nance of the requested erator and are not inte	services. It is expressly understood nded nor can they be construed as
	ents and expressions of opinion reflect the opinions or observation ies. Acuren Group Inc. is not assuming any responsibilities of the provided by Acuren Group Inc. In no event shall Acuren Group In					ir and use decisions as a result of the
	provided, Acuren Group Inc. uses the degree, care and skill ordina					No other warranty, expressed or
implied, is made or intende	d by Acuren Group Inc.				· · · · · · · · · · · · · · · · · · ·	
SIGNATURES			1			
CLIENT REPRESEN	NTATIVE JASON HURSCH		SIGNATURE	Ur I	TR#	
TECHNICIAN (SIGNA	ITURE):			REPORT	ov·	
	Chagnon Frederic	. k		REVIEWED	NAME	INITIALS
NAME (PRINT):	1 <sup>st</sup> TECHNICIAN		2 <sup>ND</sup> TECHNICIAN			
	CGSB LEVEL SNT LEVEL CGSB REG. NO 10560	CGSB LE		LEVEL		
	CGSB REG. NO		G. NO			

Thursday, 24/07/2008 4:19:28 PM

User:

Julie Lecocq

**Process Sheet** 

Customer : CU-DAR001 Dart Helicopters Services Job Number

: 40749

**Estimate Number** 

: 10559

P.O. Number

**Previous Run** 

This Issue

: 24/07/2008

Prsht Rev. : NC

First Issue

: 24/07/2008

: 40119

Type

S.O. No. :

: CROSSTUBES

Material

**Due Date** 

ÉC

JLM

**Drawing Name** 

**Part Number** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: 12/08/2008

: D

: D412664203

: HIGH AFT X-TUBE 412

: D412-664-243 REV D

1 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev:E 04.02.16 Est Rev:F 06-03-29 Est Rev:G 06.12.08

Remove Coments on Pick List JLM per ECN 886

Est Rev:H 07-04-30 As per Rev D

Reformat: Added D3189-1 K/DS

Est Rev:I

08-06-12 add comment in seq. 21 DD verified

by:EC

REFERENCE ONLY

Qty:

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description: DOCUMENT CONTROL

1.0

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

2.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0 D412664203TRN Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit

1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch

BENDING 4.0

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

Job Completion

